



Dart Aerospace Ltd.
1270 Aberdeen St
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Canada

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D3953-21
Job Sheet 199852



Part No: D3953-21

Job Qty: 40 pcs

Part Name: Gas Spring Bracket



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/3/19

Job Tracking No:

Due Date: 9/27/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV C IPP RevA: new issue DD 09.11.30 verified by:EC IPP Rev:B as per dwg revC DD 10.03.02 verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	40 pcs	9/27/19	9/27/19	0.17	1.43	Waterjet - Flow	10/9/19	JRB
110	QC 2	40 pcs	9/27/19	9/27/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		

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Container No: S221465

Part: D3953-21

Job No: 199852

Serial No/Batch: S221465

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 10/09/19

9/3/2019

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

120 QC 8	40 pcs	9/27/19	0.00 0.00	QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	6/9/19 JRB
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	DAS
				QC 8 - 9	40
				QC 8 - 68	9-89
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	DAS
				QC 8 - 40	81
				QC 8 - 52	9-89
				QC 8 - 23	
				QC 8 - 57	
					OCT 15 2019
130 Small Fab - 2 - B4B	40 pcs	9/27/19	0.00 4.00	Small Fab - 1 - B4B	DAS
				Small Fab - 2 - B4B	58 OCT 17 2019
				Small Fab - 3 - B4B	Q 80
				Small Fab - 4 - B4B	
				Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
				Small Fab - 8 - B4B	
140 QC 5	40 pcs	9/27/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	OCT 17 2019
				QC 5 - 61	DAS
				QC 5 - 81	40
					9-89
150 Packaging 3-1 - Stock - B4B	40 pcs	9/27/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	

Plex 9/3/19 1:51 PM Dart.lajeunesse.marie

				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	PC FP001
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
160 QC 21 - SA	40 pcs	9/27/19	0.00 0.00	QC 21 - SA - 21	DAS 21 9-30
				QC 21 - SA - 70	
				QC 21 - SA - 53	
Part Op 100 - 1-Cut as per Dwg D3953 Descriptions: 110 - QC2- Inspect parts off machine FAI/FAIB 120 - QC8- Inspect parts - second check 130 - Small Fab - 1- CHAMFER HOLE AS PER DWG 140 - QC5- Inspect part completeness to step on W/O 150 - Identify as per dwg & Stock Location: _____ 160 - QC21- Final Inspection - Work Order Release					OCT 2 1 2019
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
M304S11GA	304/316 0.125 Sheet	.5760 sf (.0144 ea)	100-Waterjet - Flow - 1	S216338	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-Waterjet - Flow - 1	M304S11GA	1	25	0	
Part Specifications					
Specifications could not be found.					

DART AEROSPACE LTD		Work Order: 199852
Description: Gas Spring Bracket		Part Number: D3953-21
Inspection Dwg: D3953	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.194	+0.005/-0.001	0.195			DC-02V	
Ø0.257	+0.006/-0.001	0.259				
0.625	+/-0.010	0.629				
1.38	+/-0.030	1.38				
0.38	+/-0.010	0.38				
0.375	+/-0.010	0.381				
1.00	+/-0.030	1.02				
1.500	+/-0.010	1.507				
0.125	+/-0.010	0.120				

Measured by: JRB	Audited by: DAS	Preliminary Approval:
Date: 10/9/19	Date: 81 OCT 15 2019	Date:

Rev	Date	Change	Revised by	Approved
A	10.06.07	New Issue	KJ	



Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only ☐

NCR No. _____

Job: _____

Part No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐

DEPARTMENT/PROCESS

Skid-tube ☐ Eng. (Non-AW) ☐ Engineering ☐
Machining ☐ Prod. Eng. Coord. ☐ Water Jet ☐
Large Fab ☐ Rec/Store/Packaging ☐ Supplier ☐
Finishing ☐ Quality ☐

Date: _____ Sequence #: _____

QTY Affected: _____

MRB (QS1042)

Description Work Order Deviation

Disposition

Completed By _____

Lead hand / Supervisor _____

QC / QA Coordinator _____

Root Cause

Operator ☐
Manufacturing Process ☐
Equip/Tooling ☐
Handling/Preservation ☐
Material ☐
Product Improvement ☐
Process Improvement ☐
Human Factors ☐

FAULT CATEGORY

Pressure/Forced	Contamination	Power Loss/Surge	Positioned Wrong
Bending	Misaligned/off center	Folio/Program	Outside Tolerance
Crushing	BOM/Route	Grain Direction	Drawing
Cracks	Broken/Damage/Defect	Weld	Finish
Crimp/Kink/Ripple/Wave/Twist	Incomplete/Unclear Instructions	Wrong Stock Pulled	Part Lost/Missing
Marks/Chatter	Drill Holes	Out of Sequence	Misread
Mislabeled	Fit/Function	Off-set/Set-up	

Other/Details: _____